

Date: Tuesday, 7/11/2006 1:40:36 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY
Job Number	: 27859B		
Estimate Number	: 10852	Part Number	: D3324041
P.O. Number	: N/A	Drawing Number	: D3324 UNDER REVIEW ^{PH} 06-07-11
This Issue	: 7/11/2006 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: B
First Issue	: 7/11/2006 Type : LARGE FAB ASSY	Material	: N/A
Previous Run	: 27858B	Due Date	: 8/15/2006 Qty: 1 Um: Each
Written By	: <u>See Comment Below</u>		
Checked & Approved By	: <u>PH 06-07-11</u>		
Comment	: Est Rev:A 05.02.09 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D33283	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3328-3 Hinge Plate

B23727PH 06/08/02

2.0	D33481	Clevis
-----	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3348-1 Clevis

B24713PH 06/08/02

3.0	D33493	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3349-3 Spacer Bushing

B23758PH 06/08/02

4.0	D33671	Mounting Bracket
-----	--------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3367-1 Mounting Bracket

B23862PH 06/08/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
				83.1.1				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/11/2006 1:40:36 PM
User: Kim Johnston

Process Sheet

D

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 27859B

Part Number: D3324041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M4130NTS0500W035

4130 Square tube .5 x .5



Comment: Qty.: 48.9300 f(s)/Unit Total : 48.9300 f(s)
Material: 4130 Cond. N Square tube per MIL-T-6736,
1/2" x 0.035" wall
M4130N-TS0.500W.035)

M17678

AA 06/08/02

6.0

M569EX05018F

569 Expanded Metal



Comment: Qty.: 28.0000 sf(s)/Unit Total : 28.0000 sf(s)
Pick:

Qty Part Number Description

Batch

28s, M569EX0.50-18F 1/2"-18gauge(.040") carbon steel

M101738

AA 06/08/02



PD

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1-Cut tubes as per Dwg D3324

Qty Part Number Description Batch

3 D3324-1 Bottom Tube

4 D3324-3 Full Length Tube

2 D3324-5 Top End Tube

2 D3324-7 Bottom End Tube

10 D3324-9 Vertical Tube

Identify parts appropriately

M17679

2-Remove all markings from material & check for foreign objects

3-Drill and Weld as per Dwg D3324 & QSI 004 using DT8781 A & B

ARN/A Steel Rod

4/30 Rod

M19430

4-Deburr as required

AA 06/08/02

8.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-08-02



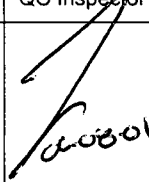
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POSITIVE RECALL


EFFECTIVE 06-08-01 AUTH

RELEASED 06-08-02 DATE

Signature

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-08-01	6	waiting upon Mat'l Certs.					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
			7					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 26/08/04

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/11/2006 1:40:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 27859B

Part Number: D3324041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

06-08-02

(1)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

060803/1

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

N/A

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/04

Job Completion



C206108/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

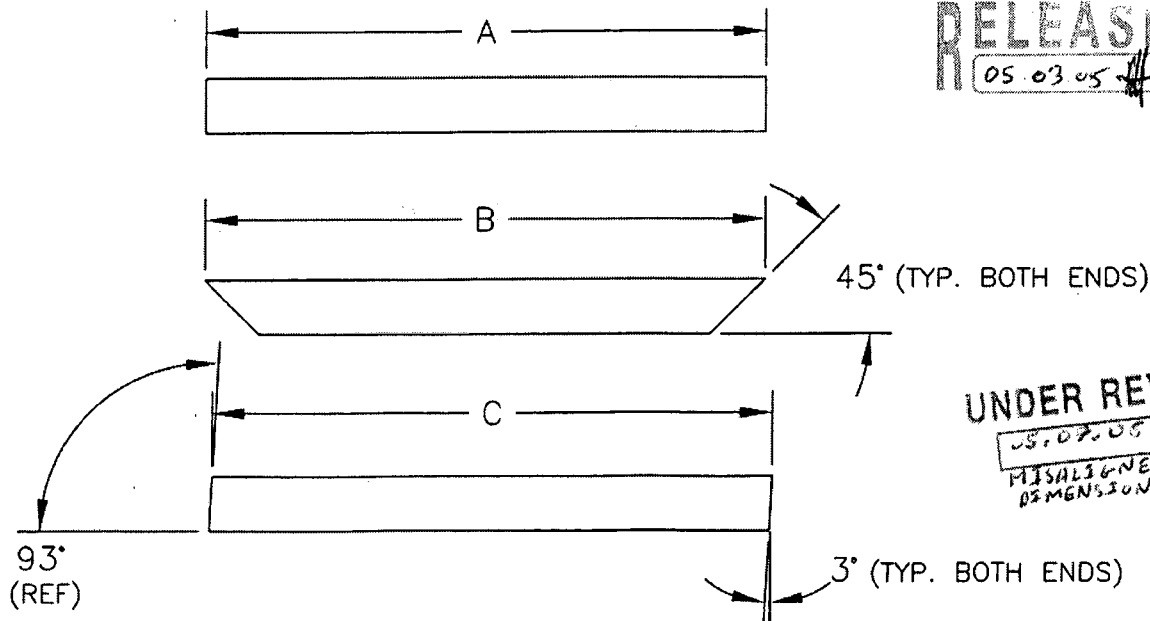
QA: N/C Closed: _____ Date: _____



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



RELEASED
05.03.05

UNDER REVIEW
05.03.05 PH
MISALIGNED
DIMENSION P/L

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035" WALL (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 27859 B

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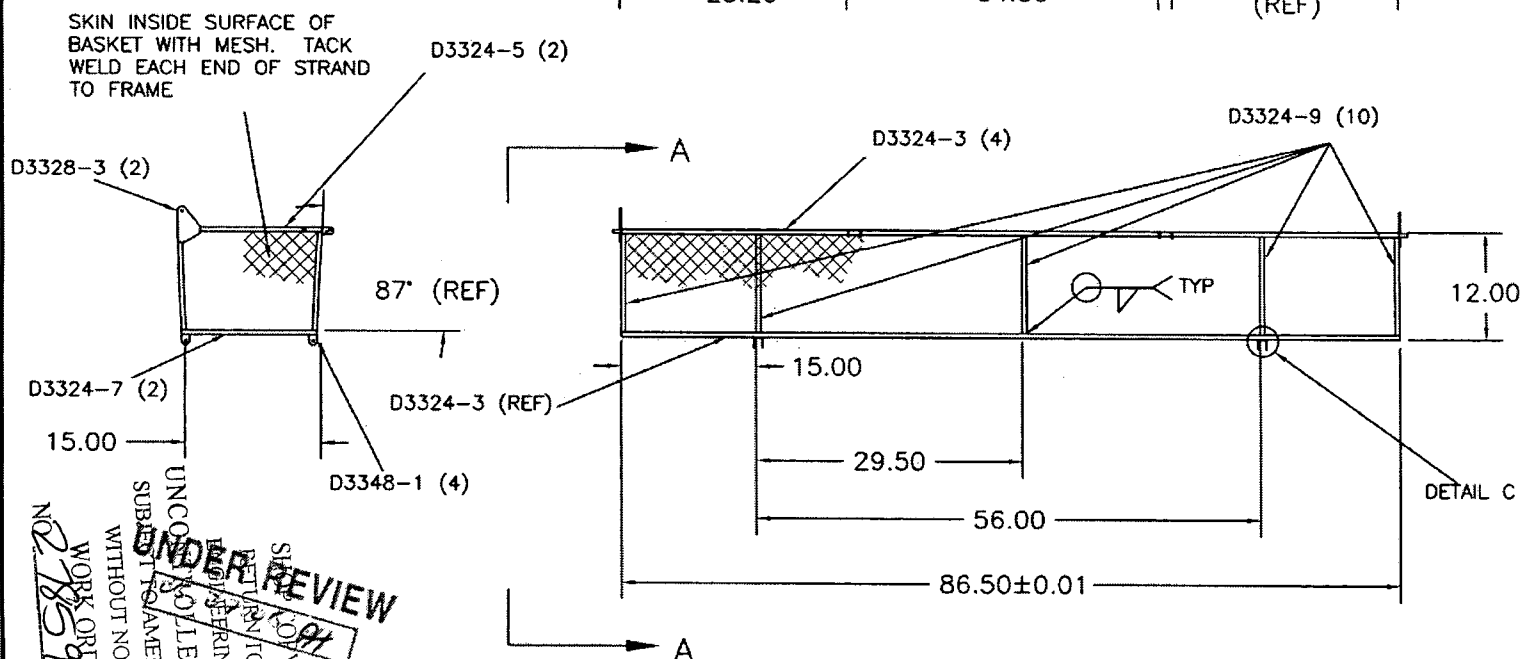
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
05.03.04	05.03.04	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 3
D3324	D3324		
DATE	TITLE	BASKET BASE ASSEMBLY	SCALE
			1:20

RELEASED
05.03.05

SKIN INSIDE SURFACE OF BASKET WITH MESH. TACK WELD EACH END OF STRAND TO FRAME



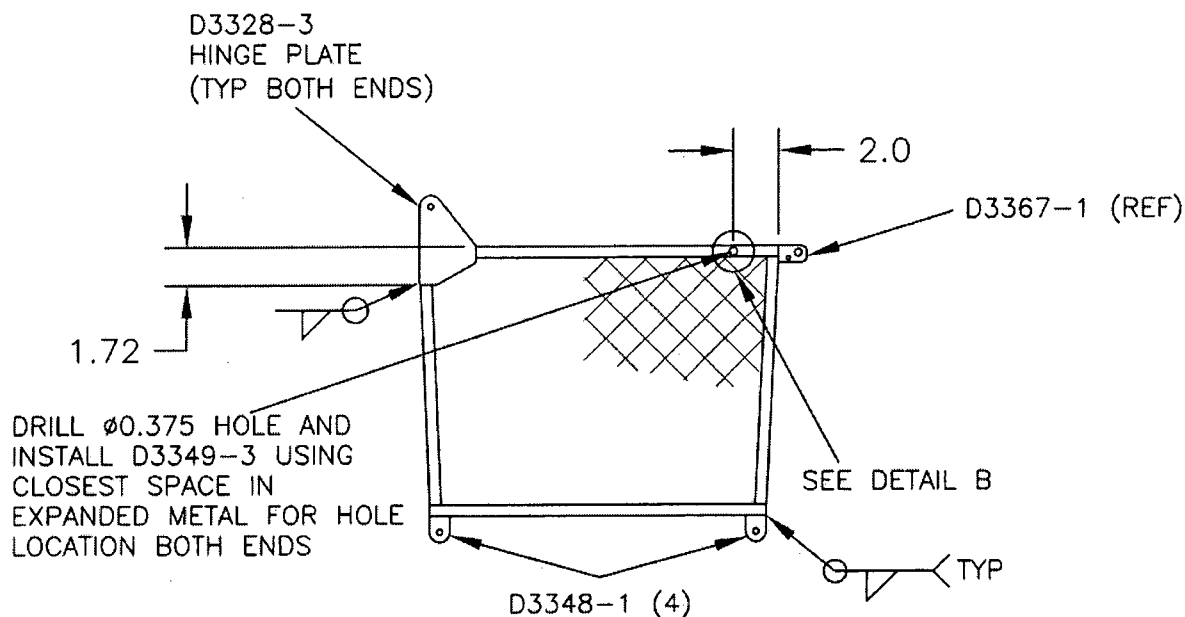
D3324-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

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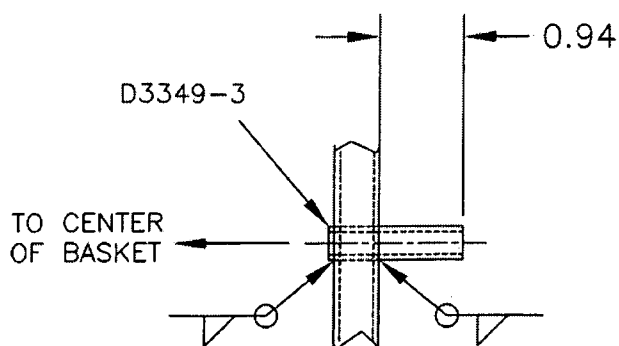


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8

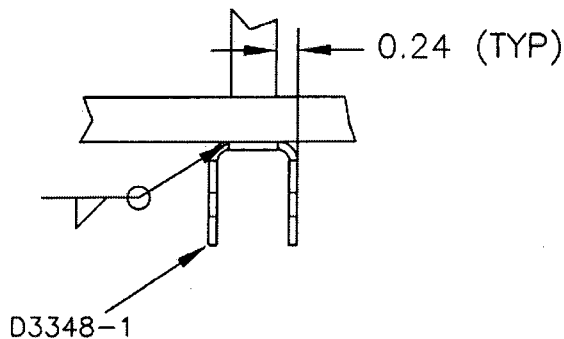


VIEW A-A

RELEASED
05.03.05



DETAIL B
(SCALE 1:2)



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UNDER REVIEW
05.07.06

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935, boul. du Havre
Valleyfield (Québec)
J6S 5L1

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FAX: (450) 37

VENDU À / SOLD TO:

613-632-3336

513-632-4443

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

DART AEROSPA
1270 ABERDEE
HAWKESBURY,
ONTARIO
K6A 1K7

VOTRE N° DE COMMANDE / YOUR P.O. N°	VEND. / SALESM.	CODE CLIENT / CUST. CODE	EXPEDIE PAR / SHIP VIA	TE
1725	JB	DAER		

✓	NOMBRE QUANTITY	CODE DE PRODUIT PRODUCT CODE	COMMANDE ORDERED	EXPÉDIE SHIPPED	DESCR
	M		24	3x 2x12'	RDD 4130 3/4" 2 X 12' ✓
		FMD1218F	2	2x4' 1x20'	EXPANDED METAL 2 X 4' X 8' ✓
	6				

* Unités de mesure: CLB Cent livres Hundred pounds • CPI Cent pieds Hundred feet • UN Unité Unit • PI Pied Foot • PC Pied carré Square foot

CONDITIONS

ES MATERIAUX LIVRES ET FACTURES SONT QUILS DECRITS DEMONTRENT LA PROPRIÉTÉ DE "ACIER CAMPI INC." JUSQU'À PARFAIT PAIEMENT COMPLET ENCAISSÉ. - LES RISQUES DE PÉRIES DU BIEN SONT À LA CHARGE DE L'ACHETEUR. - LA GARANTIE DE QUALITÉ DU MATÉRIEL EST LA MÊME QUE CELLE DU FABRIQUANT. - L'ACHETEUR S'ENGAGE À RESPECTER LES CONDITIONS SUIVANTES : NET 30 JOURS DE LA DATE DE FACTURATION, ET TOUT COMPTÉ IMPAYÉ DANS LES 30 JOURS ENTRAÎNE DES FRAIS DE 2% PAR MOIS (24% PAR ANNEE) QU'IL ACCEPTE DE PAYER. - TOUT DÉFAUT EXÉCUTER L'UNE OU L'AUTRE DES OBLIGATIONS EN VERTU DU PRÉSENT CONTRAT ENTRAÎNE LA DÉCHARGE DU DÉMÊT ET PERMET AU VENDEUR, S'IL OÙ CHAQUE, DE RÉCLAMER TOUT SOLDE DU PRIX DE VENTE DU BIEN VENDU. - TOUTE RÉCLAMATION DOIT ÊTRE FAITE DANS LES 30 JOURS DE LA DATE DE FACTURATION DE CE DOCUMENT. - TOUTE MARCHANDISE ENDOMMAGÉE, PÉRIÉE OU CONTRAÎNE SE PEUT ÊTRE REPRISE. - À UN RETOUR DE MARCHANDISE NE SERA ACCEPTÉE SANS NOTRE AUTORISATION. - TOUTE MARCHANDISE RETOURNÉE EST SUIVETTE À DES FRAIS DE MAINTIEN DE 25%.

CONDITIONS

ALL SOLD AND DELIVERED MATERIALS REMAIN THE PROPERTY OF THE SELLER. ALL LOST MATERIALS ARE AT THE BUYER'S RISK. THE BUYER HEREBY ACCEPTS TO RESPECT THE PENALTY CHARGES OF 2% PER MONTH. OR CONTRACT WILL LEAD TO PAYMENT BY A FURTHER 2% PER MONTH. A SESSION OF THE GOODS SOLD. ANY DAMAGE TO THE GOODS HAS BEEN DAMAGED, CUT OR MODIFIED. THE BUYER IS SUBJECT TO A 25% RESTOCKING CHARGE.

MARCHANDISE RECUE EN BO

PRÉPARÉ / PREPARED.	VÉRIFIÉ / VERIFIED
---------------------	--------------------

PAR
BY

LIVRE / DELIVERED

HEY, TIME

PAR

10-0

N° ENR. TPS / GST REG. N° R.135 534 117 • N° ENR. TVQ / GST REG. N° 1 015 668 543

SIGNATURE DU CLIENT

Receiving Report

Batch No: 21101728
Dart P/O: 1735

Release Note Attached:	Yes	No	N/A
Waybill Attached:	Yes	No	N/A
Shipment Complete:	Yes	No	N/A
QC6 Inspection	✓		N/A
Work Order			N/A

Initials of receiver (if shipment OK) Level 12

Location

Feedback